

Date: Monday, 18/08/2008 3:41:01 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LITTER TIE DOWN ASS'Y		
Job Number	: 41337					
Estimate Number	: 10360					
P.O. Number	:			Part Number	: D2350	
This Issue	: 18/08/2008	S.O. No.	:	Drawing Number	: D2350 / D2363	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: B / F	
Previous Run	: 39221			Material	:	
Written By	:			Due Date	: 10/09/2008	
Checked & Approved By	: <u>JUL 08 8-18</u>			Qty:	6 Um: Each	
Comment	: est rev B 06.05.17 added ass'y EC					
	Est Rev:C 08-05-13 chg to revF DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6201	"T" Extrusion	
		Comment: Qty.: 1.0631 f(s)/Unit Total : 6.3788 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion <u>D36793</u>	Batch: <u>ML 08/09/14</u>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 12.150" long	<u>ML 08/09/14</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2363 and Dwg D2363 <u>Deburr</u>	<u>H.A 08/09/14</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>H.A 08/09/14</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>ML 08/09/14</u>
6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Tumble & deburr	<u>N/A</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:41:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 41337

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



AK



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(G)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MH 08/09/16

9.0

POWDER COATING

POWDER COATING



11108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:15 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

7:45 AM

08-09-17

(x6)

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 D2372

Quick Release



E 08/09/18 (6)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener

39456 X5 B41426

(2x) 8 08/09/17 (6)

12.0 D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin

41429 X5 B38895 X1

8 08/09/17 (6)

13.0 AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer

M105793

K 08/09/17 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:41:01 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 41337

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) M108701



JS 08/09/17 X6

15.0 MS27039113 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw 105211



JS 08/09/17 X6

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

INSPECT WORK TO CURRENT STEP

JS 08/09/18 ⑥

S 08/09/18 ⑥

Comment: INSPECT WORK TO CURRENT STEP

18.0 PACKAGING 1 PACKAGING RESOURCE #1



X6

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

8/9/18

SP

19.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/19 ⑧

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41337
Description: Litter Tie Down Bracket	Part Number:	D2363
Inspection Dwg: D2363	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

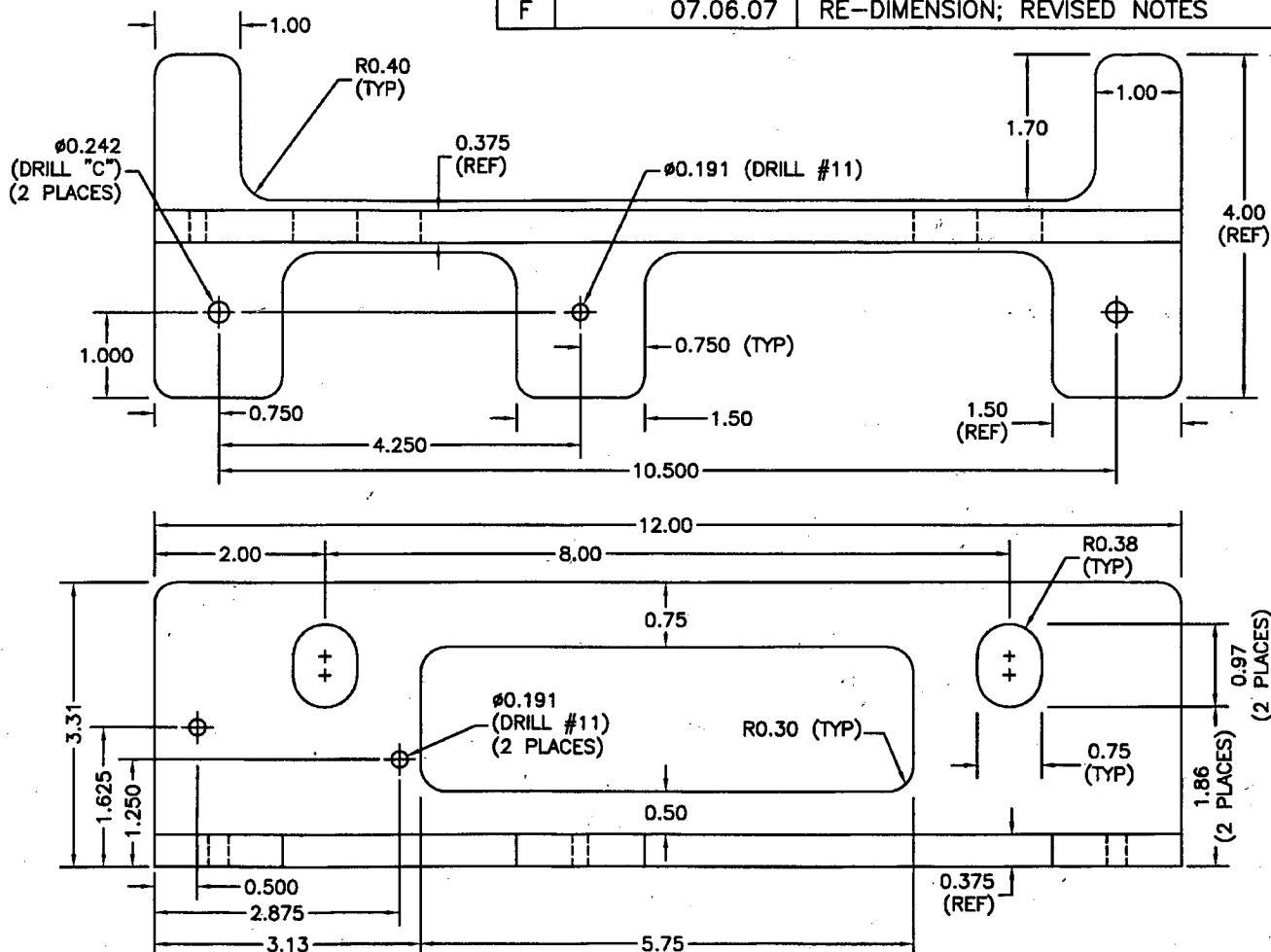
Measured by:	J.A	Audited by:	<i>JS</i>	Prototype Approval:	N/A
Date:	08/09/14	Date:	08/09/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.22	New Issue P/O D2350	KJ/JLM	
B	07.07.17	Dimensions updated per Dwg Rev. F	KJ/JLM	
C	08.05.20	3.425 dimension removed	KJ/DD	KA AS

DART

DESIGN BW	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>CH</i>	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2

A	95.01.14	NEW ISSUE
B	95.02.14	MODIFIED HOLES
C	95.03.06	0.191 WAS 0.197
D	95.03.06	CHANGES TO DIMENSIONS
E	97.10.01	CHANGES FOR MACHINING
F	07.06.07	RE-DIMENSION; REVISED NOTES

**D2363 LITTER TIE DOWN BRACKET**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION
(6061-T6/T651 PER QQ-A-200/8)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT
INK MARKER
- RELEASED
07.06.07 *[Signature]*
- △ *[Signature]*
- SHOP COPY
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WORK ORDER

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271
87



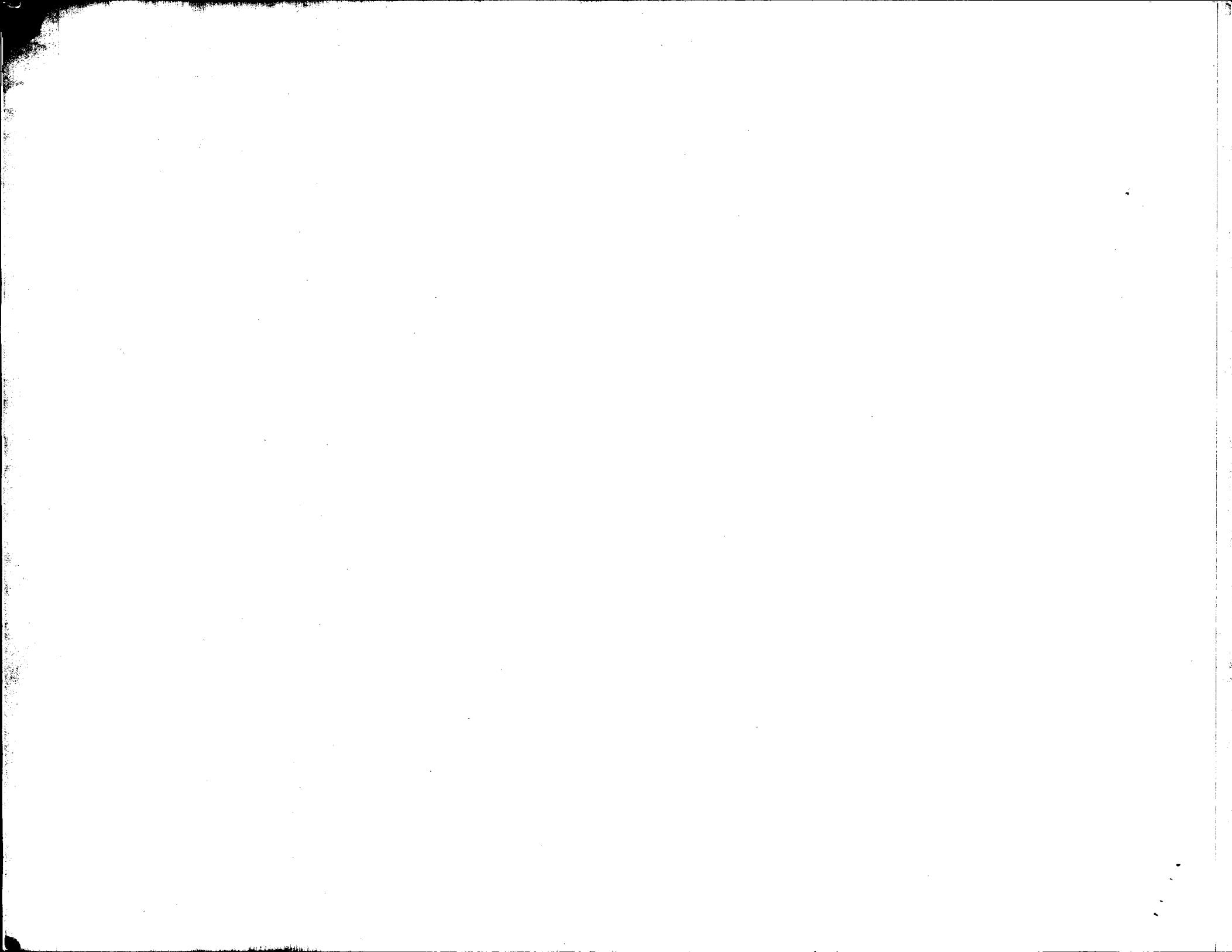
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CHECKED <i>BW</i>	APPROVED <i>JH</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
X 3	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

KE 99.04.29

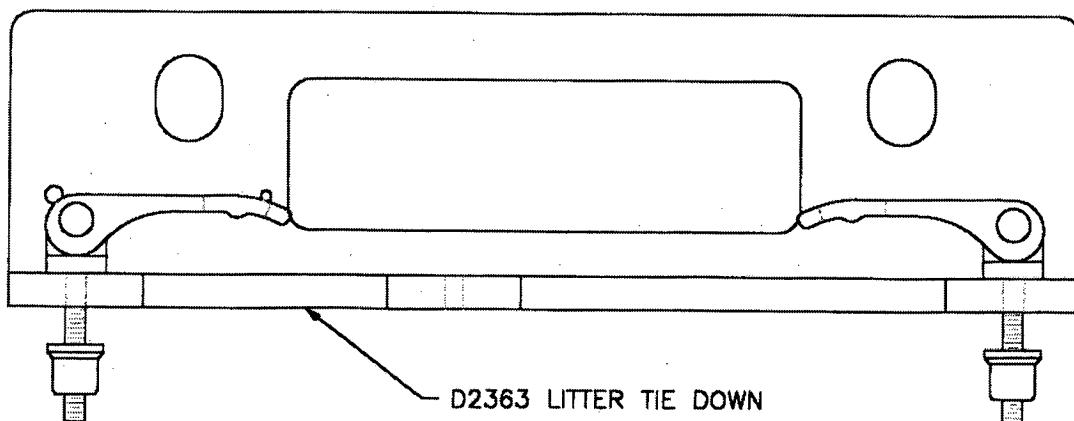
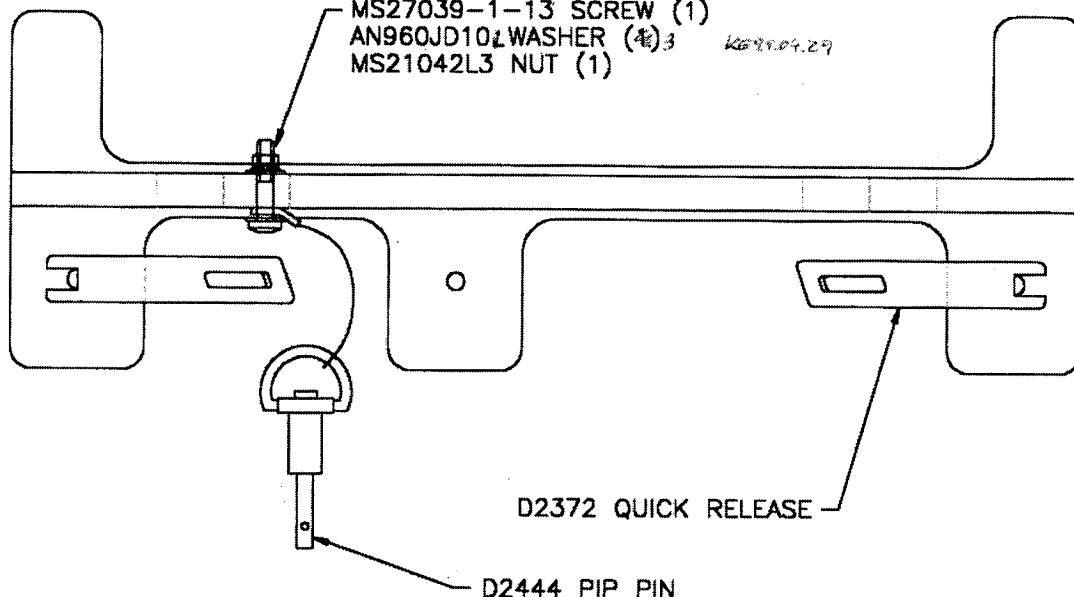
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CHECKED B W	APPROVED <i>[Signature]</i>	DRAWING NO. D2350
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY
		REV. B SHEET 2 OF 2 SCALE

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